User:

Tuesday, 6/13/2006 3:29:02 PM

Linda Lacelle

#### **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 27523

**Estimate Number** 

: 10645

P.O. Number

:NIA

: 6/12/2006

: 25484

: NC

: 6/13/2006

S.O. No. : NIK

**Part Number Drawing Number** 

**Due Date** 

**Drawing Name** 

: D2429041

: SPRING CLIP ASSEMBLY

**Project Number** 

 D2429 REV C1 : N/A

**Drawing Revision Material** 

: C1 AIG: : 6/30/2006

Qty:

Each

**Previous Run** Written By

This Issue

Prsht Rev.

First Issue

Checked & Approved By

: PURCHASED PARTS

Comment

: Est. D 02.03.06 Added note at step 7

Additional Product

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

FLOW WATER JET

Comment: FLOW WATER JET

WATER JET

2.0

1.0

M304S20GA

304/316 .040 Sheet

Comment: Qty.:

0.0500 sf(s)/Unit

Total:

0.2500 sf(s)

83

3.0

PACKAGING 1

PACKAGING RESOURCE #1



304/316 .040 Sheet

Comment: PACKAGING-RESOURCE #1

Recieive & Inspect for Transit Damage

Ensure Material Release Note is attached

INSPECT WORK TO CURRENT STEP





Comment: INSPECT-WORK TO CURRENT STEP

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAO 06:08,04 2-Bend D2429-1 as per Dwg D2429



MS20470AD45

Rivet, Universal Head





1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Rivet, Universal Head

Pick:

Comment: Qty.:

Qty Part number Description Batch



Tuesday, 6/13/2006 3:29:02 PM Date: Úser: Linda Lacelle **Process Sheet Drawing Name: SPRING CLIP ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27523 Part Number: D2429041 Job Number: Seq. #: **Description: Machine Or Operation:** MS20470AD4-5 Rivet 1 AN960JD6L 7.0 Washer 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Comment: Qty.: Washer Pick: Qty Description Batch Part number MS519 2 AN960JD6L Washer NOTE: 2 D2429-1 required for 1 assy. SAD 06:07/20 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 8.0 Comment: Assemble D2429-041 as per Dwg D2429 SAD 06:07! 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 10.0 PACKAGING PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 5741 DOCUMENT CONTROL 11.0 Comment: DOCUMENT CONTROL Inspection Level 21 \$ 06.07.24 Job Completion

Qty:

Monday, 6/12/2006 3:43:20 PM

User:

Kim Johnston

**Process Sheet** 

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** 

: 27523 : 10645

P.O. Number This Issue

: 6/12/2006

S.O. No. :

: NC

: // First Issue

: 25484

Type

: PURCHASED PARTS

Part Number

**Drawing Name** 

: D2429041

**Drawing Number** 

: D2429 REV C1

: SPRING CLIP ASSEMBLY

**Project Number Drawing Revision** 

: N/A : C1

Material

**Due Date** 

: 6/30/2006

5 Um: Each

Written By

Prsht Rev.

Checked & Approved By

Comment

**Previous Run** 

: Est. D 02.03

Added note at step 7

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

PURCHASING

1264



Comment: PURCHA

Note: Qty 2 pleces required per assembly

Make 02429-1 Alat Pattern as per Dwg D2429

Material release note required

2.0

7D242917



Comment: Qty .: 1.0000 Each(s)/Unit

Spring Clip Ass'y

06:06:20

3.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieive & Inspect for Transit Damage

Ensure-Material-Release-Note-is-attached

4.0

INSPECT WORK TO CURRENT STEP



Comment: INSPECT



WORK TO CURRENT STEP

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2429-1 as per Dwg D2429



## Dart Aerospace Ltd

W/O:		WORK ORDER CHA	NGES					-
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-20	1 6	Add Note for 2 pieces regid for lassing.			÷			
		Perm. Change.			. 1			d.5770

NCR:		,	WORK ORDE	R NON-CONFORMAN	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification		
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
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		*		•				
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		* * *		×				
		,						

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: I	1/C C	losed:	Date:

Monday, 6/12/2006 3:43:20 PM Date: User: Kim Johnston **Process Sheet Drawing Name: SPRING CLIP ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27523 Part Number: D2429041 Job Number: Description: Seq. #: **Machine Or Operation:** MS20470AD45 6.0 Rivet, Universal Head Comment: Qty.: 5.0000 Each(s) 1.0000 Each(s)/Unit Total: Rivet, Universal Head Pick: Description Batch Qty Part number MS20470AD4-5 Rivet 1 7.0 AN960JD6L Washer Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Washer Pick: Qty Part number Description Batch AN960JD6L Washer NOTE: 2 D2429-1 required for 1 assy. SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 8.0 Comment: Assemble D2429-041 as per Dwg D2429 9.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 10.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: DOCUMENT CONTROL 11.0 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

#### **Dart Aerospace Ltd**

Duit	ici ospace	<b></b>							
W/O:		The state of the s	WORK ORDER (	CHANGES					
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
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			*						
									, , , , , , , , , , , , , , , , , , , ,
NCR:		1	WORK ORDER NON-CON	FORMANC	E (NCF	R)			
		Description of NC	Corrective Action	on Section B		Vorifi	cation	Approval	Approval
DATE	STEP	Description of NO	Initial Action Des	crintion	Sign 8	veilli	Jaulon	Approvai	Approval

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification		Annroval		
DATE	STEP	Section A	<b>Initial</b> Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector		
				*						
				•		Ē				
				*						
		# 121   1200   •			7					
		•		(4) 1 42			21.			

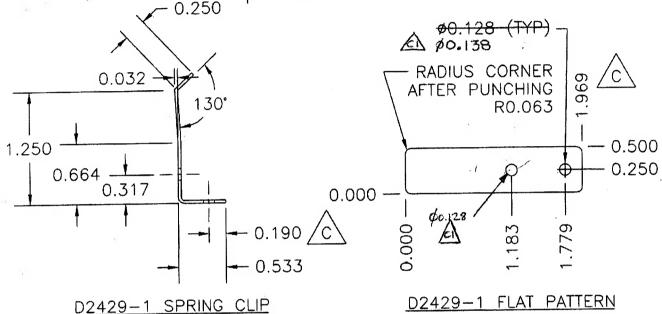
Part No:	PAR #: Fault Cate	gory: NCR:	Yes No	DQA:	Date:
NOTE: Date & initial all entries	v.	A 1	QA: N/C C	losed:	Date:

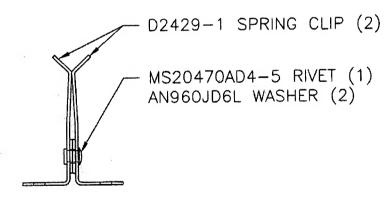


DESIGN KE	DRAWN BY	DART A	AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO. D2429	REV. SHEET 1 QI	
DATE		TITLE	SC	ALE
00.06.26		SPRING CLIP		1;

# BELEASED

DAIL			1	
00.0	6.26		SPRING CLIP	1 :
Α	1	95.07.21	NEW ISSUE	
В		97.10.09	ADDED ASSEMBLY	_
C		00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
CI	10 df	01.03.27	Ø 0.138 WAS Ø 0.128	
	00.0 A B	00.06.26 A B	00.06.26  A 95.07.21  B 97.10.09  C 00.06.26	OO.06.26       SPRING CLIP         A       95.07.21       NEW ISSUE         B       97.10.09       ADDED ASSEMBLY         C       00.06.26       1.969 WAS 2.100; 0190 WAS 0.321





D2429-041 SPRING CLIP ASSEMBLY

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COP SUBJECT TO AMENDMEN WITHOUT NOTICE

WORK ORD

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSION ARE IN INCHES

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DART AEROSPACE LTD	Work Order: 27523
Description:	Part Number: D2429-1
Inspection Dwa: Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.183	±0,010	南1.178		<u> </u>	Vern	
1,779	+0,010	1.775			Vern	
0.250	±0.010	0.246	/		Vern	
0,500	20,010	0.495			Vern	
1,969	±0,010 +0,005/-0,001	1.966			Vern	
\$0.138		80.141			Vern	,
\$0,138 \$0,128	40,005/-0,001	00.129			Vern	
	100				-	
	1000					
	3/192-27					
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24						
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				4		

Measured by: SAD	Audited by: NS	Prototype Approval:	
Date: 66:06:20	Date: Oclocal 20	Date:	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	